

Mating Part
5499

Dart Aerospace Ltd.
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Canada

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D5627-1

Job Sheet 196100



Part No: D5627-1

Job Qty: 12 pcs

Part Name: Tube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/6/19

Job Tracking No:

Due Date: 7/5/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: D5627 REV.B IPP REV:A 18.04.04 NEW ISSUE DD VERF:JFS IPP REV:B 18/08/03 AS PER DWG REV.B
JFS VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	12 pcs	7/5/19		0.00	3.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
120	QC 5	12 pcs	7/5/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
123	Conventional Mill - 1 - B4B	12 pcs	7/5/19		0.00	3.00	Conventional Mill - 1 - B4B		
							Conventional Mill - 2 -		

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126 QC 5	12 pcs	7/5/19	0.00 0.00	B4B					
				QC 5 - 10					
				QC 5 - 12					
				QC 5 - 17					
				QC 5 - 18					
				QC 5 - 19					
				QC 5 - 22					
				QC 5 - 24					
				QC 5 - 3					
				QC 5 - 43					
				QC 5 - 49					
				QC 5 - 51					
				QC 5 - 58					
				QC 5 - 68					
				QC 5 - 9					
				QC 5 - 50					
				QC 5 - 30					
				QC 5 - 40					
				140 Handfinish - 1-1 Chemical-B4B	12 pcs	7/5/19	0.00 1.20	Handfinish - 1 - 1 - B4B	
Handfinish - 1 - 2 - B4B									
Handfinish - 1 - 3 - B4B									
Handfinish - 1 - 4 - B4B									
Handfinish - 1 - 5 - B4B									
Handfinish - 1 - 6 - B4B									
Handfinish - 1 - 7 - B4B									
Handfinish - 1 - 8 - B4B									
Handfinish - 1 - 9 - B4B									
Handfinish - 1 - 10 - B4B									
Handfinish - 1 - 11 - B4B									
Handfinish - 1 - 12 - B4B									
Handfinish - 1 - 13 - B4B									
Handfinish - 1 - 14 - B4B									
Handfinish - 1 - 15 - B4B									
Handfinish - 1 - 16 - B4B									
Handfinish - 1 - 17 - B4B									
Handfinish - 1 - 18 - B4B									
Handfinish - 1 - 19 - B4B									
Handfinish - 1 - 20 - B4B									
Handfinish - 1 - 21 - B4B									
Handfinish - 1 - 22 - B4B									
150 QC 7	12 pcs	7/5/19	0.00 0.00	QC 7 - 10					
				QC 7 - 13					
				QC 7 - 14					
				QC 7 - 15					
				QC 7 - 17					
				QC 7 - 18					
				QC 7 - 19					
				QC 7 - 2					
				QC 7 - 28					
				QC 7 - 3					
				QC 7 - 30					
				QC 7 - 34					
				QC 7 - 36					
				QC 7 - 37					
				QC 7 - 41					
				QC 7 - 47					
				QC 7 - 48					
				QC 7 - 51					
				QC 7 - 58					

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					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
160	Packaging 3-1 - Stock - B4B	12 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	Pc GA 113
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170	QC 21 - SA	12 pcs	7/5/19	0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-38 JUL 09 2019

Part Op 110 - (Fabricate per Drwg) 1- CUT BLANKS at 14.00" 2- BEND AS PER DWG WITH Baileigh Hydraulic CNC Bender
 Descriptions: using D-1500T-R400-E Die Set. Bend @ 102 degrees on bender to achieve 90. USE DT _____ AS A TEMPLATE.
 SCRIBE ENDS FROM THE EDGE OF TEMPLATE AND CUT TO SIZE.

120 - (QC5- Inspect part completeness to step on W/O)

123 - 1- CHAMFER ONE INSIDE END OF TUBE AS PER DWG 2- DRILL HOLES AS PER DWG AND DEBURR
 (DT10423) AND BUFF ALL BEND MARKINGS ***VERIFY HOLES WITH D5499-1 ***

126 - (QC5- Inspect part completeness to step on W/O)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC7-Inspect Chemical Conversion Coat)

160 - Identify as per dwg & Stock Location: _____ ***GA***

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T1.500W.125	6061T6 Round Tube 1.50 X .125W	14.0400 ft (1.17 ea)	110-Large Fab - Welded Assy-1	113 7623

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	M6061T6T1.500W.125	14	15	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S194214



Part: D5627-1

Job No: 196100

Serial No/Batch: S194214

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/26/19